

Work Order ID 86083

June-20-12 12:57:05 PM

86083

Page 1

Item ID: D4464-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fuel Tank Assembly

Start Date: 20/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/06/20* Tooling:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4464	D								

100 Weld per dwg A/R Aluminum rod Batch: *120854* 0.00
122130

100

Large Fab

Large Fab

Memo

0.00

1- weld D4023-3 cap, D3999-11 earth tab and D4008-11 hinge onto D4463-11 as per dwg D4464

2- Weld D4001-1 and D4000-5 onto D4463-1 Top

2- Weld D4463-9 and D4463-11 together

2- weld D3999-041/-043 doubler followed by D3999-9 inside tank, ensure doubler and angle holes line-up for D4000-047

3- Weld D4000-043 and D4000-045 on tank as per dwg.

4- Instal D4000-9 grommets as per dwg, Weld D4463-3 aft end as per dwg, locate D4000-1 fitting using locating jig DTXXXX and weld as per dwg

5-Weld D4463-7 fwd end

PURGE INSIDE OF TANK

1 *φ* *12.07.11*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

1 0 BE 12/07/11

120

Weld per dwg A/R Aluminum rod Batch: 120254 0.00

120

Large Fab

Memo

0.00

Large Fab

1-Weld top D4463-1 using DT9811 and DT9810

PURGE INSIDE OF TANK

1 0 12-07-18

123

QC5- Inspect part completeness to step on W/O

0.00

123

QC

Memo

0.00

Quality Control

Pressure Test as per dwg D4464

DAS
16
9-53

7/10/12

Passes work + fulcrum Power
test

RTO

W/O: 86083		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4464-041 PAR #: _____ Fault Category: Large Fabb Welding NCR: Yes No QA Date: 12/08/14
 Resolution: _____ Disposition: Rework QA: N/C Closed: SD Date: 12/08/14

NCR: 12-1688		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/14/24	# 20	Found AT inspection multiple leaks on the base of the tank while performing the water & vacuum powder test R.C. Process.	DAS 22 9-89 12.07.24	touch up locations marked from QC inspections to per 002 005 4/12 120854	12-07-25	DAS 16 9-89 12/07/25	DAS 22 9-89 12.07.24	DAS 16 9-89 12/07/24

NOTE: Date & initial all entries

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fuel Tank Assembly

Start Date: 20/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC9- Inspect visual per QSI004- Fusion Welds

0.00

140

QC

Memo

0.00

Quality Control

1 0 12/07/25 

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

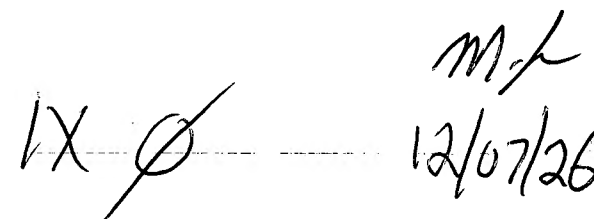
HandFinish

Memo

0.00

Hand Finishing

1- brush alodine on tank. No alodine inside

IX 

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

1 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Revision ID:
Item Name: Fuel Tank Assembly

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N900040100

Setup Start ***NS1***
Stop ***NS2***

Start Date: 20/06/2012 Start Qty: 1.00 ***1***
Required Date: 04/07/2012 Req'd Qty: 1.00 ***1***

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170

0.00

170

Powdercoat

Powder Coating

Memo

0.00

Mask prior to powdercoat

POWDER COAT ANSI 61 GREY AS PER DWG AND QSI 005 4.3

Start Time: 9:30

Oven Temperature: 320 OF

Finish Time: 10:00

180

QC3- Inspect Part Finish

0.00

180

QC

Quality Control

Memo

0.00

M118535

1X

M/L
12/07/26

10

PRD 7-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

0.00

190

Small Fab

Small Fab

Memo

0.00

1- Mask off area, where access cover is applied

2- Abrade surface with red scotch brite

3- Wipe with clean cloth and wash and wipe

4- Assemble as per dwg and for D4577-041/-3/-5 access panels install wet with proseal 890

A/R proseal 890 Batch:

1122441

200

QC5- Inspect part completeness to step on W/O

0.00

200

QC

Memo

0.00

Quality Control

tested with water

and air pressure @ 4.5 psi.

DAS
16
2-08-10

(tl)

12-08-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.11.23 NEW ISSUE DD VERF:EC IPP REV:B
12.03.08 AS PER DWG REV.B DD VERF:EC IPP REV:C 12.04.24
ECN 12-571 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3997-5

Manufactured No

190

Each

8.0000

2

2

✓

D3997-5

**

Placard

JB

Location

Loc Qty

Loc Code

ST141

98

72611

82

81028

8

83650

8

81028

D3997-11

Manufactured No

190

Each

11.0000

1

1

✓

D3997-11

**

Placard

JB

Location

Loc Qty

Loc Code

ST141

11

82957

11

82957

D3997-17

Manufactured No

190

Each

13.0000

1

1

✓

D3997-17

**

Placard

JB

12/07/25

Location

Loc Qty

Loc Code

ST141

13

80309

3

82958

10

80309

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 86083

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Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3997-29

Manufactured No

190 Each

14.0000

1

1

**

20

D3997-29

Placard

Location

Loc Qty

Loc Code

ST141

14

80845

14

80845

D3997-43

Manufactured No

190 Each

11.0000

1

1

**

80310

20

12/07/25

D3997-43

Placard

Location

Loc Qty

Loc Code

ST141

11

82960

11

D3999-7

Manufactured No

100 Each

5.0000

1

1

**

12-07-11

D3999-7

Corner

Location

Loc Qty

Loc Code

WA014

5

71695

1

75156

4

D3999-9

Manufactured No

100 Each

4.0000

1

1

**

12-07-10

D3999-9

Angle

Location

Loc Qty

Loc Code

WA014

4

71696

1

82545

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 86083

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

86083

D4464-041

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3999-11

Manufactured No

100

Each

18.0000

1

1

12.07.10

D3999-11

Earth Tab

Location

Loc Qty

Loc Code

WA

25

84161

17

WA013

-8

WA014

1

~~75180~~

1

Manufactured No

100

Each

9.0000

1

1

12.07.11

D4000-1

D4000-1

Fuel Supply Fitting

Location

Loc Qty

Loc Code

WA

9

~~80029~~

1

83811

8

Manufactured No

100

Each

7.0000

1

1

12.07.11

D4000-5

D4000-5

Fuel Tank Vent Fitting

Location

Loc Qty

Loc Code

WA013

7

~~80030~~

1

83813

6

Manufactured No

100

Each

2.0000

3

3

12.07.16

D4000-9

D4000-9

Grommet

Location

Loc Qty

Loc Code

WA014

2

~~83814~~

2

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 86083

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

86083

D4464-041

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 1.00

Required Qty: 1.00

D4000-045

Manufactured No

100

Each

3.0000

1

1

**

12.07.23

D4000-045

Fuel Pickup Fitting Assembly

Location

Loc Qty

Loc Code

WA

387919

1

~~81071~~

1

WA013

1

~~72078~~

1

WA014

1

~~71669~~

1

D4008-11

Manufactured No

100

Each

8.0000

1

1

**

12.07.10

D4008-11

Hinge Half

Location

Loc Qty

Loc Code

WA

8

~~80037~~

2

80838

6

D4008-041

Manufactured No

190

Each

3.0000

1

1 ✓

**

JB 12/07/25

D4008-041

Fuel Filler Splash Guard Assembly

Location

Loc Qty

Loc Code

ST108

3

84013

3

84013

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 86083

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

86083

D4464-041

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 1.00

Required Qty: 1.00

D4023-3

Manufactured No

190

Each

16.0000

1

1

**

12.07.10

D4023-3

Cap and Flange

Location

Loc Qty

Loc Code

ST084

15

81898

5

84422

10

ST110

1

~~73514~~

1

Manufactured No

190

Each

9.0000

1

1

**

JB 12/07/25

D4025-5

D4025-5

Fuel Quantity Sender

Location

Loc Qty

Loc Code

ST141a

4

76894

1

81899

3

ST143

5

84421

5

Manufactured No

100

Each

24.0000

3

3

**

12.07.16

D4057-1

D4057-1

Retaining Ring

Location

Loc Qty

Loc Code

WA013

24

~~71166~~

2

83656

22

Manufactured No

190

Each

2.0000

1

1

**

12.07.18

D4062-041

D4062-041

Tank Support Assembly

Location

Loc Qty

Loc Code

WA

2

85235

2

June-20-12 12:57:09 PM

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

86083


D4464-041

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 1.00

Required Qty: 1.00

 D4124-1
D4124-1
Tab

Manufactured No 100 Each 21.0000 4 4

**

12.07.18

Location Loc Qty Loc Code

WA 21

~~76895~~ 7

83824 14

4

D4125-1
D4125-1
Sump

Manufactured No 100 Each 3.0000 1 1

**

12.07.10

Location Loc Qty Loc Code

WA 3

~~81151~~ 1

83825 2

1

D4125-3
D4125-3
End

Manufactured No 100 Each 3.0000 1 1

**

12.07.10

Location Loc Qty Loc Code

WA 3

~~81152~~ 1

83826 2

1

D4404-3
D4404-3
Cushion, Side

Manufactured No 100 Each 1.0000 1 1

**

12/07/25

Location Loc Qty Loc Code

ST242A 1

76898 1

1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

86083

D4464-041

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 1.00

Required Qty: 1.00

D4404-5

Manufactured No

100

Each

22.0000

4

4

**

D4404-5

Cushion, Fwd

JB 12/07/25

Location

Loc Qty

Loc Code

ST242A

22

76899

1

85596

21

85596

D4462-1

Manufactured No

100

Each

6.0000

1

1

**

D4462-1

Baffle

12.07.11

Location

Loc Qty

Loc Code

WA

6

83827

2

84353

4

D4462-3

Manufactured No

100

Each

4.0000

1

1

**

D4462-3

Baffle

12.07.11

Location

Loc Qty

Loc Code

WA

4

84355

4

D4463-041

Manufactured No

120

Each

2.0000

1

1

**

D4463-041

Tank Top Assembly

12.07.11

Location

Loc Qty

Loc Code

WA

2

84826

2

D4463-3

Manufactured No

100

Each

0.0000

1

1

**

D4463-3

Tank Aft End

12.07.11

384354 = (1)

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

86083

D4464-041

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 1.00

Required Qty: 1.00

D4463-5

Manufactured No

100

Each

8.0000

1

1

**

12.07.11

 *D4463-5*
Tank Upper Cut Out

Location

Loc Qty

Loc Code

WA

8

83834

8

Manufactured No

100

Each

0.0000


1

1

**

12.07.11

D4463-7

 *D4463-7*
Tank Fwd End

D4463-9

Manufactured No

100

Each

4.0000

1

1

**

12.07.11

 *D4463-9*
Tank Back

Location

Loc Qty

Loc Code

WA

4

84358

4

Manufactured No

100

Each

2.0000

1

1

**

12.07.10

D4463-11

 *D4463-11*
Tank Front

Location

Loc Qty

Loc Code

WA

2

84766

2

Manufactured No

190

Each

3.0000


1

1

**

12.07.10

D4463-13

 *D4463-13*
Tank Bottom

Location

Loc Qty

Loc Code

WA

3

886575

2

~~82237~~

1

~~83834~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-20-12 12:57:10 PM

Page 9

Work Order ID: 86083

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

86083

D4464-041

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN3H5A

Purchased

No

190

Each

27.0000

5

5

AN3H5A

Bolt

**

JB

Location

Loc Qty

Loc Code

ST351

27

118112

1

120693

26

120693

MS21042L3

Purchased

No

190

Each

1,654.000

4

4

MS21042L3

Nut

**

JB

Location

Loc Qty

Loc Code

ST300

1654

117885

32

119017

816

119075

138

121444

668

121444

MS35206-266

Purchased

No

190

Each

92.0000

4

4

MS35206-266

Screw

**

JB

12/07/25

Location

Loc Qty

Loc Code

ST294

92

119850

92

119850

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Page 10

Work Order ID: 86083

Parent Item: D4464-041

Parent Item Name: Fuel Tank Assembly

86083

D4464-041

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

190

Each

1,425.000

37

37

✓

NAS1149D0363.J

Washer

**

JB

Location

Loc Qty

Loc Code

ST298

1425

116025

2

117601

61

118612

3

119537

33

120142

13

120308

17

121243

342

121524

954

121524

AN3-4A

Purchased

No

190

Each

559.0000

24

24

✓

AN3-4A

Bolt

**

JB

Location

Loc Qty

Loc Code

ST350

559

102832

88

104291

4

104625

81

107321

8

117317

98

120308

80

120770

200

104625

D4577-1

Manufactured

No

190

Each

3.0000

1

1

✓

D4577-1

Rear Access Panel

**

JB

12/07/25

Location

Loc Qty

Loc Code

ST237A

3

84365

3

84365

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Page 10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

Picklist Print

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Page 11

Work Order ID: 86083

86083

Parent Item: D4464-041

D4464-041

Parent Item Name: Fuel Tank Assembly

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 1.00

Required Qty: 1.00

D4577-3

Manufactured No

190

Each

3.0000

1

1

**

JB

D4577-3

Middle Access Panel

Location

Loc Qty

Loc Code

ST237A

3

85719

3

85719

D4577-041

Manufactured No

190

Each

3.0000

1

1

**

JB

12/07/25

D4577-041

Fwd Access Panel Assembly

Location

Loc Qty

Loc Code

ST237A

3

84368

3

84368

NAS 1149D03327
12-08-08

QTY: 5x

B# M121708

12/08/08

AN3-6A
12-08-08

QTY: (4x)

B# M120644

12/08/08

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Page 11

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4464-041	FUEL TANK ASSEMBLY
2	2	D3997-5	PLACARD "AUX FUEL DRAIN"
3	1	D3997-11	PLACARD "LOADING"
4	1	D3997-17	PLACARD "STOWAGE"
5	1	D3997-29	PLACARD "WARNING"
6	1	D3997-43	PLACARD "EARTH"
7	1	D3999-7	CORNER
8	1	D3999-9	ANGLE
9	1	D3999-11	EARTH TAB
10	1	D4000-1	FUEL SUPPLY FITTING
11	1	D4000-5	FUEL TANK VENT FITTING
12	3	D4000-9	GROMMET
13	1	D4000-045	FUEL PICK UP AND STRAINER ASSEMBLY
14	1	D4008-11	TANK HINGE HALF
15	1	D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY
16	1	D4023-3	FUEL CAP
17	1	D4025-5	FUEL SENDER
18	3	D4057-1	RETAINING RING
19	1	D4062-041	TANK SUPPORT ASSEMBLY
20	4	D4124-1	TAB
21	1	D4125-1	FWD SEDIMENT BOWL
22	1	D4125-3	AFT SEDIMENT BOWL
23	1	D4404-3	CUSHION, SIDE
24	4	D4404-5	CUSHION, FWD
25	1	D4462-1	BAFFLE
26	1	D4462-3	BAFFLE
27	1	D4463-041	TOP TANK ASSEMBLY
28	1	D4463-3	TANK AFT END
29	1	D4463-5	TANK UPPER CUT OUT
30	1	D4463-7	TANK FORWARD END
31	1	D4463-9	TANK BACK
32	1	D4463-11	TANK FRONT
33	1	D4463-13	TANK BOTTOM
34	1	D4577-041	FWD ACCESS PANEL ASSEMBLY
35	1	D4577-1	REAR ACCESS PANEL
36	1	D4577-3	MIDDLE ACCESS PANEL
37	24	AN3-4A	BOLT
38	5	AN3H5A	BOLT
39	4	MS21042L3	NUT
40	4	MS35207-266	SCREW
41	37	NAS1149D0363J	WASHER

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26083 MCT

12/06/20

RELEASED
2012-05-09
MCT

D	ADDED NOTE RE HAND FORMING D4124-1, ZN A8-4	DC	12.05.02
C	UPDATED -041 WITH RE-DESIGNED D4463-11/13 REV. C PARTS, ZN B6-2. UPDATED -041 WITH RE-DESIGNED D4577-041/1-3/5 PARTS, ZN C6-2.	DC	12.03.27
B	UPDATED -041 WITH RE-DESIGNED PARTS, REMOVED D4463-13. ADDED D4577-041/1-1/5 ACCESS PANELS, ZN C6-2.	DC	11.12.14
A	NEW ISSUE, REF PAR11-117 & CAR 11-54	DC	11.10.19
REV	DESCRIPTION	BY	DATE
DESIGN	BC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BC		
CHECKED	BC	DRAWING NO.	REV. D
MFG. APPR	BC	D4464	SHEET 1 OF 5
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	TANK ASSEMBLY	NTS
DATE	12.05.02	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

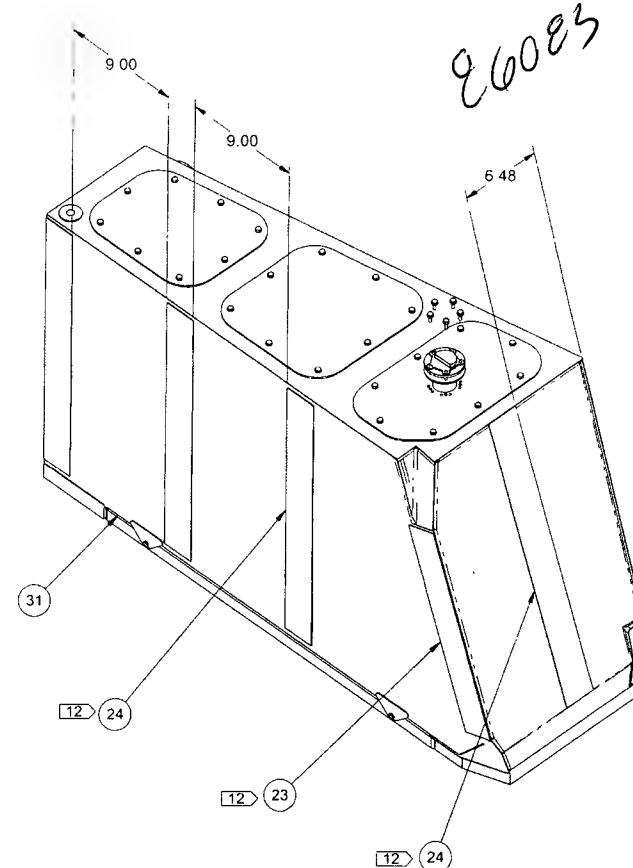
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASE
2012-05-09

- 1) MATERIAL: N/A
- 2) FINISH: TOUCH UP CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D350-794-141" USING D2729-1 RED DECAL
- 7) WEIGHT: 35.81 lbs
- 8) CAP ALL TANK ACCESS POINTS AND PRESSURE TEST TANK PER QSI 038 4.3. VERIFY NO LEAKS
- 9) MASK PRIOR TO POWDER COAT
- 10) INSTALL AFTER POWDER COAT
- 11) LOCKWIRE BOLTS AFTER INSTALLATION PER AC 43.13 OR MS33540
- 12) INSTALL CUSHIONS AFTER POWDER COAT USING CONTACT CEMENT. TRIM TO FIT IF REQUIRED
- 13) INSTALL D4577-0411-3/-5 ACCESS PANELS WET WITH PROSEAL 890.

DESIGN	<i>JS</i>	DART AEROSPACE LTD	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>JS</i>	D4464	SHEET 2 OF 5
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	TANK ASSEMBLY	
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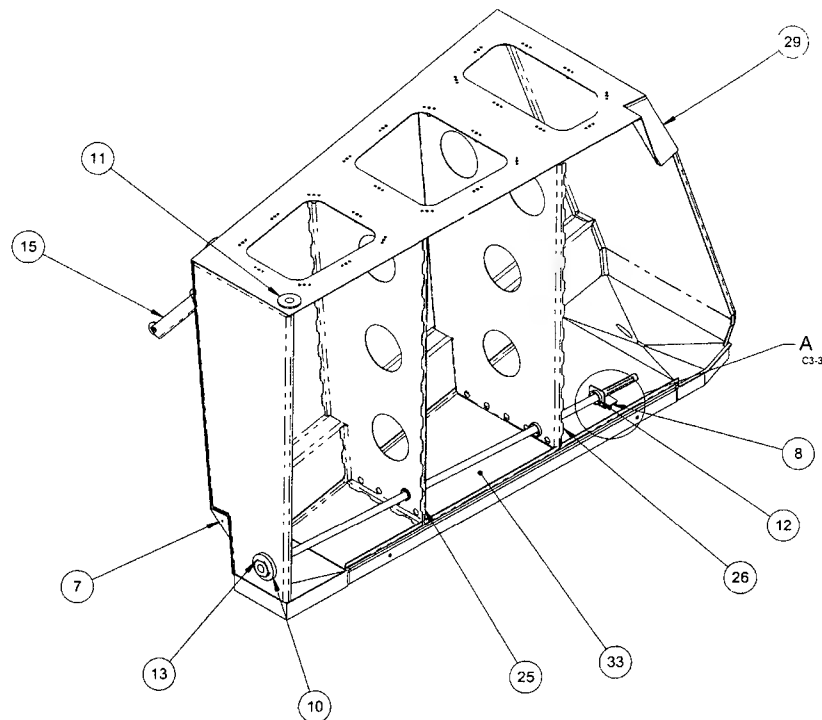
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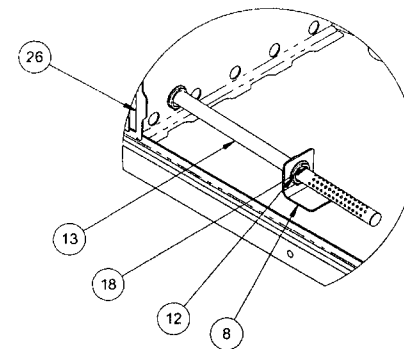
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D4464-041 FUEL TANK ASSEMBLY
D4463-9 TANK BACK REMOVED
TO SHOW INTERIOR DETAIL



DETAIL A
ROTATED FOR CLARITY
SCALE 2X

86-3

RELEASED
 2012-05-09
W

DESIGN		DART AEROSPACE LTD	
DRAWN	<i>BC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BC</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>BC</i>	D4464	SHEET 3 OF 5
APPROVED	<i>W</i>	TITLE	SCALE
DE APPR.	<i>W</i>	TANK ASSEMBLY	NTS
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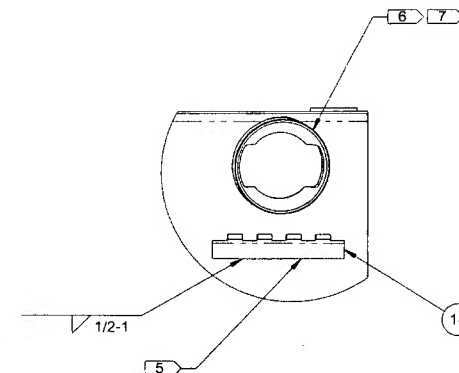
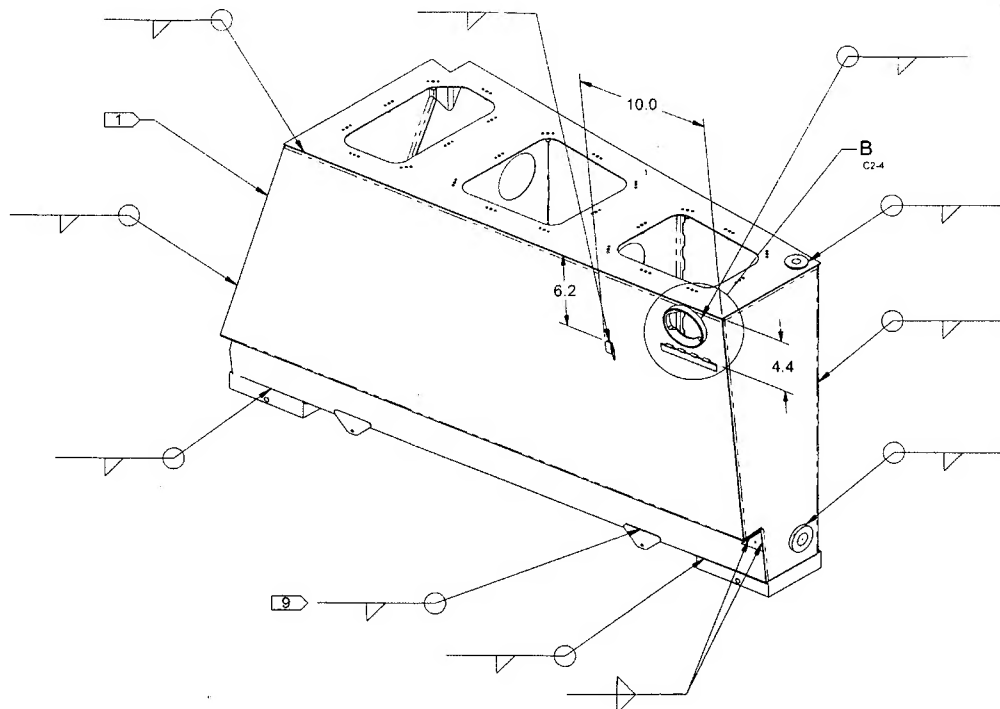
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NOTE: Date & initial all entries



DETAIL B
ROTATED FOR CLARITY
SCALE 2X
C2-4

D4464-041 FUEL TANK ASSEMBLY
WELDING DETAIL

NOTES:

- 1) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
- 2) FINAL CHECK BEFORE LAST PANEL INSTALLED
- END OF FUEL PICK UP TUBE IS 0.60 OFF THE TANK FLOOR AND 1.96 FROM SIDE WALL
- ALL SWARF REMOVED
- 3) ACCEPTABLE TO DRILL 6 (TYP) $\varnothing 0.312$ HOLES IN TANK TOP TO WELD TOP TO AFT BAFFLE (1 HOLE PER BAFFLE TAB)
- 4) ACCEPTABLE TO DRILL 7 (TYP) $\varnothing 0.312$ HOLES IN TANK TOP TO WELD TOP TO FWD BAFFLE (1 HOLE PER BAFFLE TAB)
- 5) CENTER HINGE BELOW FUEL CAP FLANGE
- 6) POSITION FUEL CAP FLANGE AS SHOWN, ELONGATED HOLE APPROXIMATELY HORIZONTAL
- 7) POSITION FUEL CAP FLANGE SO THAT INNER FACE IS FLUSH WITH INSIDE OF TANK
- 8) WELD PER DART QSI 004
- 9) USE THE D4062-041 TANK SUPPORT ASSEMBLY TO POSITION THE D4124-1 TABS BEFORE WELDING:
D4124-1 TABS MAY BE HAND FORMED AS REQUIRED TO FIT D4062-041 ASSEMBLY BEFORE WELDING.



RELEASED
2012-05-09

DESIGN	<i>JP</i>	DART AEROSPACE LTD	
DRAWN	<i>BC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BC</i>	DRAWING NO. D4464	REV. D
MFG. APPR.	<i>PE</i>	SHEET 4 OF 5	
APPROVED	<i>WJ</i>	TITLE	SCALE
DE APPR.	<i>WJ</i>	TANK ASSEMBLY	NTS
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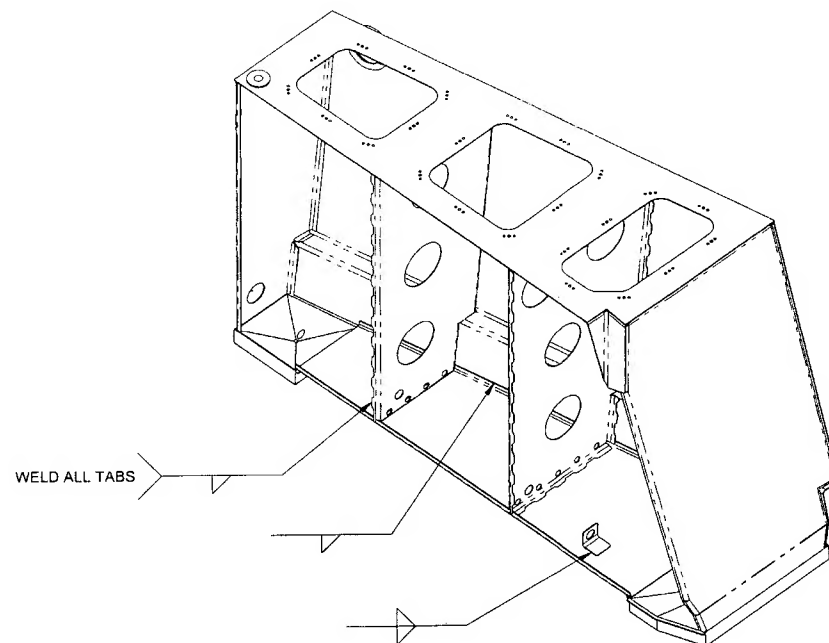
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NOTE: Date & initial all entries

46083



**D4464-041 FUEL TANK ASSEMBLY
WELDING DETAIL**

RELEASED
2012-05-09
MR

DESIGN	BC	DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO. D4464	REV. D
MFG. APPR.	BC	SHEET 5 OF 5	
APPROVED	MR	TITLE	SCALE
DE APPR.	MR	TANK ASSEMBLY	NTS
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